

split

Dart Aerospace Ltd.

Date: Tuesday, 5/23/2006 8:13:06 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
 Job Number : 27169 - 1
 Estimate Number : 10313
 P.O. Number : N/A Part Number : D26483
 This Issue : 5/23/2006 S.O. No. : N/A Drawing Number : D2648 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D
 Previous Run : 25904 Material : N/A
 Due Date : 6/5/2006 Qty: 400 Um: Each
 Written By :
 Checked & Approved By : 06.05.23
 Comment : Est: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 1312
 Email or ship DXF file to vendor
 Make per Drawing D2648-1
 Material release note required

C 206/05/24

(400)

2.0 D26483F Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 400.0000 Each(s)
 WEARPAD

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material release note is attached

AR 06/06/06 402

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06.06.06 402
 AS per 05.01.06

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

N/A SA 06/06/06 402

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 5/23/2006 8:13:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 27169

Part Number: D26483

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D2648-3

SAD

06:06:02

402

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R560Hardcoat

M100942

M101217

1-Weld as per Dwg D2648 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

H.M 06/06/13

402

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

HA 06/06/13

402

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

HA 06/06/13

402

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DU 06/09/04

220

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 09 07

220

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP17

FC 06 09 07

220

13.0

DC

DOCUMENT CONTROL




Comment: DOCUMENT CONTROL

Inspection Level 21


LG 06/09/07

W 06/09/07

220

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-03	10	split w/o, need Qty of 182 for on split - 2 Qty remaining, 220 on this w/o	gl	06/08/01	$\frac{182}{220}$		 06-08-03

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 06/09/07

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

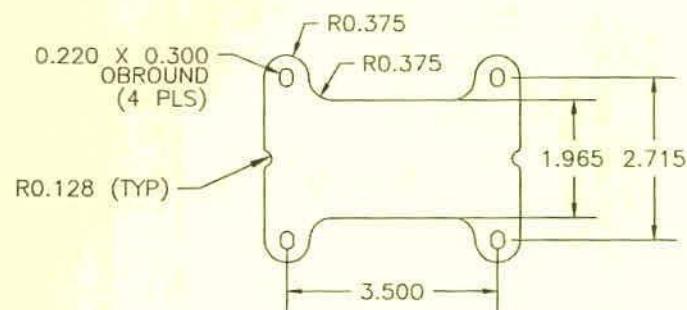
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

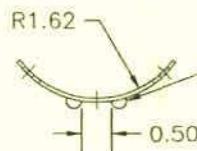
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

D2648-1 FLAT PATTERN

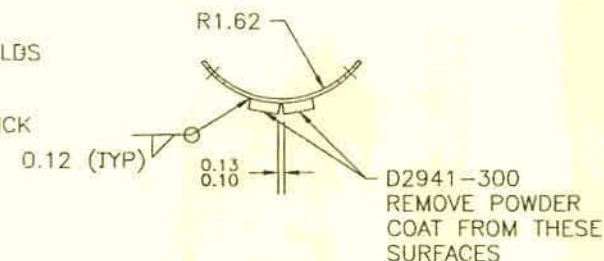


SECTION A-A

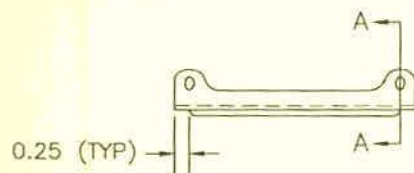


7560 HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.063 TO 0.125 THICK

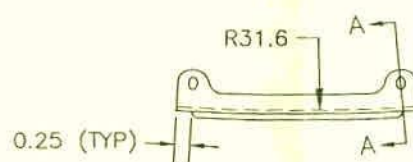
SECTION B-B



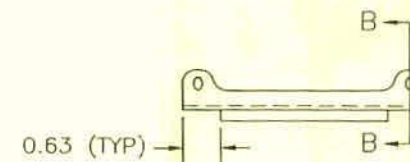
D2648-3 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-5 LONGITUDINAL BEND (MADE FROM D2648-1)



D2648-7 LONGITUDINAL BEND (MADE FROM D2648-1)



RELEASED
11.12.20 05



BREAK ALL SHARP CORNERS 0.063 MAX
MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

NO. 27169
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
166

D	99.11.17	ADDED D2648-7
C	97.06.26	R31.6 WAS R19.6
B	97.05.30	ENLARGE OBOUND, 0.375 WAS 0.250
A	97.03.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2648
DATE		TITLE WEARPAD
99.11.17		REV. D SHEET 1 OF 1 SCALE 1:2

8

100 827148
551013 MD

California Steel Industries
14000 San Bernardino Ave.
Fontana, California 92335
Ph (909) 350-6300

CERTIFIED TEST REPORT

CUSTOMER ORDER P50614ME002		MO. NUMBER 02-8344-01	SHIPPING DATE 08/01/05	CAR NUMBER RR: WCTR142061	TALLY NUMBER PO 250499136 1/
B I L L T O WILKINSON STEEL AND METALS A DIVISION OF PREMETAL CO., INC. 888 S.E. MARINE DR., VANCOUVER BC, CANADA, V5X2V3			S H I P T O WILKINSON STEEL-METALS C/O GARY R. HAMILTON TRUCKING 888 S.E. MARINE DR., VANCOUVER BC, CANADA BC V5Y 2		

MARK ALL DOCUMENTS W/P.O. P50614ME002. FAX TALLIES AT TIME OF SHIPMENT TO MEL ELIAS FAX #604-301-3244.

END USE	WAREHOUSE STOCK - NON-CRITICAL SURFACE
PROD	H.R. COILS - P & O - PRIME
SPEC	ASTM-A-1011-00-CS-TYPE B

T/R	INSPECTION	MILL
DESCRIPTION		COILS, PRECES OR BUNDLES
.0605 x 48.0000 x COIL		1
NOM ME		1
		HEAT NUMBER
		T42354
		T42348

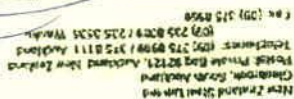
I CERTIFY THE FOLLOWING TEST INFORMATION TO BE CORRECT AS CONTAINED IN THE RECORDS OF THE COMPANY.

Auto D. Jenkins

CHIEF - LABORATORY SERVICES

MECHANICAL PROPERTIES							CHEMICAL ANALYSIS															10:48:05 08/01/05 CC		
HEAT OR LOT NUMBER	SLAB NUMBER	L O C	YIELD KSI	TENSILE STRENGTH KSI	% ELONGATION		BEND TEST	C	Mn	P	S	Si	Cu	Ni	Cr	Mo	Al	V	Co	Ti	N			
					8"	2"																		
T42354								08	.39	010	006	006	01	01	01	00	050	000	000	000	002			
T42348								08	.38	014	010	007	01	01	01	00	046	000	000	001	003			
CTR-001 PTLUC22L 990712																								

CTR-001 PTLUC22L 990712



THE SMITHSONIAN

PAGE 1 of 1

DATE	17 January 1946
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169815 H2O TIME

CUSTOMER ON 40-31N-108

CUSTOMER WILLIAMS 1511 ADM E003

SPECIFICATION

PRODUCT

0.1010 0.1010

CHEMICAL COMPOSITION PERCENT

MECHANICAL TESTS (TEST SPECIFICATION)

[illegible]

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION.

APPROVED ✓
Dash Mistry

860410MCO13-2 T M INDUSTRIAL 1P5122MCO3.040846

